

Date: Friday, 5/9/2008 10:22:30 AM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: NO STEP LABEL		
Job Number	: 39139			Part Number	: D2137		
Estimate Number	: 10160			Drawing Number	: D2137 REV 93.29.06		
P.O. Number	:			Project Number	: N/A		
This Issue	: 5/9/2008	S.O. No.	:	Drawing Revision	: 93.29.06		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: PURCHASED PARTS	Due Date	: 5/16/2008	Qty:	20
Previous Run	: 37068			Um:	Each		
Written By	:			Comment			
Checked & Approved By	: <u>JUL 08 509</u>			SM			
Comment : Est: B 02.02.01 Added step 3 and inspection level 21							

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 Comment: PURCHASING Issue P/O <u>6334</u> Make per Dwg 2137
2.0	D2137P	Decal - No Step
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) DECAL- NO STEP
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC5	INSPECT WORK TO CURRENT STEP
		 Comment: INSPECT WORK TO CURRENT STEP
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>S113</u>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/9/2008 10:22:30 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NO STEP LABEL

Job Number: 39139

Part Number: D2137

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/09 AF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-29

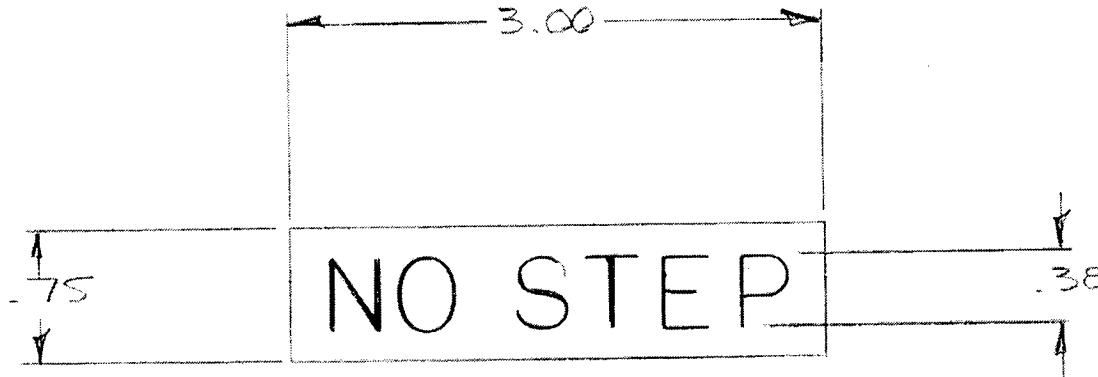
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

04/09/05/09
W/O: 39139



ALTERNATE MATERIAL:

3M 7 MIL MASKING FILM #8522EP

SILVER OR WHITE ON BLACK

~~off set 0.905~~
~~(P) 0.505~~

MATERIAL: 3M POLYESTER

NATURAL (SILVER OR
WHITE) ON BLACK.
.003 THICK



REVISION			RIVET CODE SHALL BE PER NAS 523		PART NO	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN			BASIC CODE		DIA. DASH NO. M=HEAD NEAR SIDE F=HEAD FAR SIDE	CONTRACT NO.			
APPROVED			O=DIMPLE D=DIGIT-NUM OF SHEETS C=COUNTERSINK		LENGTH DASH NO W=SPOTWELD	DRAWN	DATE		
DESCRIPTION	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED					DESIGN	4/27/09		
OF CHANGE	GENERAL	LIMITS	O=DIMPLE D=DIGIT-NUM OF SHEETS C=COUNTERSINK	BASIC CODES		STRESS			
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .010 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL .5 - .7742 5. HOLES PER MIL 10387 6. SYMMETRY ABOUT ALL M/C CENTRE LINES .005	1. TOLERANCES — .001 ± .010 2. ANGLES .007 3. PARALLELISM .00075 4. LENGTH .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005	EJ=M20410AD DE=M20426AD		CHECKED				
	REPORT ALL DISCREPANCIES — DO NOT SCALE				CLIENT				
					COOK	DWG NO	D 2137	REV	
						SCALE	1:1	SHT	1 OF 1



210 MAIN W.
HAWKESBURY, ONT. K6A 2H6
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Fax: 613 632-9491
www.studiolettrage.on.ca

INVOICE / FACTURE

No.: 10240
DATE: 05/12/2008
PAGE 1 of 1
Re: Quote No. 5062

VENDU À:
SOLD TO:

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario K6A 1K7

LIVRÉ À:
SHIPPED TO:

Dart Aerospace Ltd
Hawkesbury, Ontario

Po 633

ITEM ARTICLE	QTY QUÉ	UNIT UNITÉ	DESCRIPTION	GST TPS	PST TVP	UNIT PRICE PRIX UNITE	AMOUNT MONTANT
		20 1	D2137P printing set up E - GST @ 5% G - GST @ 5%; PST @ 8% GST PST Exempt: #6122-5207	G E		1.25 50.00	25.00 50.00
GST/TPS: R122278690							
<i>Po 6334</i> <i>Po 634</i>							TOTAL

Sold By:

Marc-O-Loup St-Aubin



Scotchcal™ Opaque Imaging Media 8522

Description

This media is specially formulated to dry quickly after printing. Production of outdoor weatherable and long-term indoor durable graphics is now easier than ever. Its changeable adhesive allows easy removal for up to one year.

Advantages

- Optimized for use with selected Epson Stylus Pro printers and Epson Archival inks.
- Optimized for use with selected HP DesignJet Printers and HP DesignJet Ink System UV or HP83UV Color Ink System
- For making opaque, laminated graphics that are outdoor weatherable and long-term indoor durable
- Media:
 - For opaque (reflective) graphics
 - Changeable, easy to remove from warranted substrates up to 1 year later
 - Dries quickly after printing so the overlaminates can be applied almost immediately
 - Low slippage paper liner for superior tiling
- Overlaminates:
 - Provide additional UV (ultraviolet) and physical protection for making weatherable finished graphics
 - Available in luster and matte gloss
 - Adhesive allows for heat-assisted or cold-temperature lamination

Applications and Uses

3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 is intended only for ink jet printing and for use with the listed Compatible Products and Equipment and the following applications. Any other application is NOT warranted by 3M or covered by the worldwide 3M™ MCS™ Warranty unless 3M gives its prior written approval for the application.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
 - Graphics for vans, personal vehicles, trucks and buses
 - Novelty posters
 - Retail and point-of-purchase displays
 - Information graphics such as maps and directories
 - Entertainment promotions in museums, zoos, parks, theatres, sports venues
 - Education and presentation graphics

Product Bulletin 8522

Release F, Effective January 2003
Black bar in margin indicates a change

- Legal and courtroom exhibits

- For flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications

Limitations of End Uses

The following uses and applications are specifically NOT warranted.

- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wall-board
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.

Note: Standard ink jet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this bulletin. Staying in the middle of these ranges always provides optimum performance.

Compatible Products and Equipment

Thermal Ink Jet Printing Systems

- Epson Stylus Pro 9500, Stylus Pro 10000 printer
 - Epson Archival Inks
- Epson Stylus Pro 10600 printer
 - Epson Archival Inks
- HP DesignJet Printers 2000 and 3000 series
 - HP DesignJet Ink System UV (pigment-based ink)
- HP DesignJet Printers 5000 series
 - HP83UV Color Ink System

Overlaminates (required)

- 3M™ Luster Overlaminate 8519 (semi-gloss)
- 3M™ Matte Overlaminate 8520

Note: For the full product names of the 3M products listed on this page, please see page 1.

Warranted Substrates

Media 8522 is warranted for use on the following rigid substrates.

Some substrates may "out-gas", resulting in tiny bubbles throughout the surface of the graphic. For maximum performance, be sure the substrate you select is properly cleaned and prepared as recommended by the manufacturer. See Instruction Bulletin 5.1 for additional information.

- Alodine (anodized aluminum)
- Automotive panels (automotive painted steel)
- Fruehauf (painted aluminum)
- FRP (fiberglass reinforced plywood)
- Glass
- Imron® (polyurethane-painted metal panel)
- Acrylic
- Sintra™ board

Test and Approve Non-warranted Substrates Before Use

Media 8522 is not warranted for any substrate other than those listed above. If you want to use it for other substrates, 3M recommends that you test and approve the media for both adhesion and removal characteristics.

Characteristics

Characteristic	Description
Media	7 mil, white, opaque graphic film
Liner	Low-slippage, lay flat paper
Adhesive	Changeable, pressure sensitive
Thickness (media and adhesive)	7.5 to 8 mil (nominal)
Application substrates	See Warranted Substrates, above
Application surfaces	Flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications (no corrugations)
Application temperature range	28° to 110°F (-2° to 43°C) (air and surface)
Roll sizes	36" x 45 feet (914 mm x 13.5 m) 54" x 45 feet (1372 mm x 13.5 m)

How to Become a 3M Ink Jet Registered Fabricator

Only 3M Thermal Ink Jet Registered Fabricators are eligible to offer 3M MCS warranted graphics. In order to become certified, a fabricator must complete the requirements as specified in the 3M Ink Jet Graphics Registered Fabricator Reference Manual located on the 3M website at [www.scotchprint.com](http://scotchprint.com).

Effective Performance Life

To obtain the warranty given below, the graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3. Also see the section, Removability.

Warranted Durability

Media 8522 with Overlaminate 8519 or 8520	Epson Printers		HP Printers	
	Outdoor	Indoor	Outdoor	Indoor
Applied to Warranted Substrates	2 years	5 years	3 years	5 years

Removability

Imaging media 8522 is removable from warranted substrates for 1 year without the aid of chemical strippers or accessories. Refer to Instruction Bulletin 4.23 for additional information.

Fabrication

Graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3.

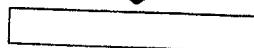
See Instruction Bulletin 4.23 for detailed fabrication, printing and mounting information.

Graphic Construction Options

Opaque (Reflective) Graphics

Opaque graphics made with imaging media 8522 require an overlaminate and an opaque substrate.

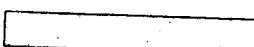
Viewer/Light Source



Overlaminate 8519, 8520
Adhesive on bottom



Imaging Media 8522
Image on top; adhesive on bottom



Opaque Substrate

Note: For the full product names of the 3M products listed on this page, please see page 1.

Shelf Life and Storage

- 3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 has a shelf life of one year.
- Storage conditions (new and partially used rolls). For optimum performance, use the middle of these ranges:
 - Original packaging, including plastic wrap
 - Relative humidity of 20% to 80%
 - Temperature of 33° to 104°F (0° to 40°C)
 - Away from direct sunlight
- Do not stack unprotected rolls or lay sharp or heavy objects on them.

Health and Safety



Caution

When handling any chemical products, read the manufacturers' container labels and the Material Safety Data Sheets (MSDS) for important health, safety and environmental information.

To obtain MSDS sheets for 3M products:

- By fax, call 1-800-364-0768 in the US and Canada or 1-650-556-8417 for all other locations.
- Electronically, visit us at <http://www.3M.com/msds>.
- By mail, or in case of an emergency, call 1-800-364-3577 or 1-651-737-6501.

When using any equipment, always follow the manufacturers' instructions for safe operation.

Warranty and Limited Remedies

3M™ MCS™ Warranty for Graphics Produced on HP DesignJet Printers and Epson Stylus Pro Printers

The following is made in lieu of all other express or implied warranties, including any implied warranty of merchantability or fitness for a particular purpose: We warrant graphics produced by a 3M Ink Jet Registered Fabricator made with imaging media 8522, printed on an approved HP thermal ink jet printer according to HP's recommendations or Epson Stylus Pro printer according to Epson's recommendations, overlaminated with 8519 or 8520, and applied to a Warranted Substrate according to 3M's recommendations. These

graphics are covered against failure caused by ultraviolet light, temperature extremes, pollution, and other elements.

If a graphic fails to perform in accordance with 3M product specifications within this time frame, 3M will replace the materials at no charge. **These remedies are exclusive. In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor charges.**

3M Related Literature

Listed below is related 3M technical literature that may be of interest. You may view and print these Bulletins from our Web site at www.scotchprint.com, or order them via our Fax-on-Demand (FOD) system. Call one of these phone numbers to order the desired bulletins, and specify the FOD document number provided in the chart.

United States or Canada: 1-800-364-0768

International: 1-651-732-6506

Subject	Bulletin No.	FOD No.
Product Bulletins		
3M™ Scotchcal™ Overlaminate 8519 and 8520	8519/8520	4524
Instruction Bulletins		
Making thermal ink jet graphics	4.23	6523
Application, substrate selection, preparation and substrate-specific application techniques	5.1	7001
Warranties		
Worldwide 3M™ MCS™ Warranty Packet (includes all Commercial Graphics MCS Warranties)		9503
Worldwide 3M™ MCS™ Warranty Overview-Folder		9504

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Sintra is a trademark of Swiss Aluminum Ltd.

Intron is a registered trademark of DuPont in the United States.

Bulletin Change Summary

The Epson Stylus Pro Printers 9500, 10000 10600, and Epson Archival Inks have been added to this bulletin. Additional changes resulting from this addition are marked with black bars in the margin.

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Fax 1-651-736-4233

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